

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013225**Date Inspected:** 16-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou Cheng/Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#19-Suspender Bracket.

During random Quality Assurance Magnetic Particle Testing (MT) review of the Suspender bracket welds, this Quality Assurance Inspector (QA) discovered the following issue:

-Total Sixteen (16) Transverse Cracks measuring approximately 15mm to 10mm in length.

-The weld is identified as: SB010-042-026.

-The weld is a seal weld joining the bracket bottom Plate (SB42E-C) to the anchor plate (X60L).

- This weld is designated as non Seismic Performance Critical Member (non SPCM) according to approved drawing (SB10).

-Total fifteen (15) transverse cracks found by ZPMC MT technician on 03-15-2010 and this weld was repaired by ZPMC personnel by SMAW process on 03-15-2010 without the prior approval of the engineer or utilizing an approved critical weld repair procedure (CWR).

Note: Please reference Incident Report written on 11-23-09, (04-0120F4_TL-15_B238_03-15-10_SB010-42_Weld Repair without CWR.). Report# 1223.

-This component is located in OBG fabrication Bay 19. The Notice of Witness Inspection Number (NWIT) is 005352. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

For further information, please see the attached pictures below. Please see incident report written on this date.

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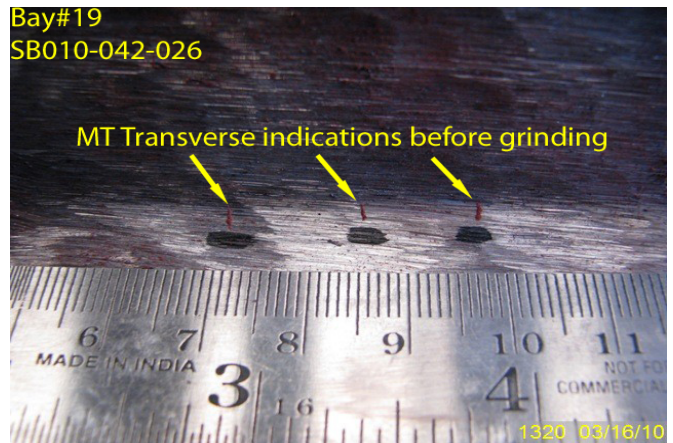
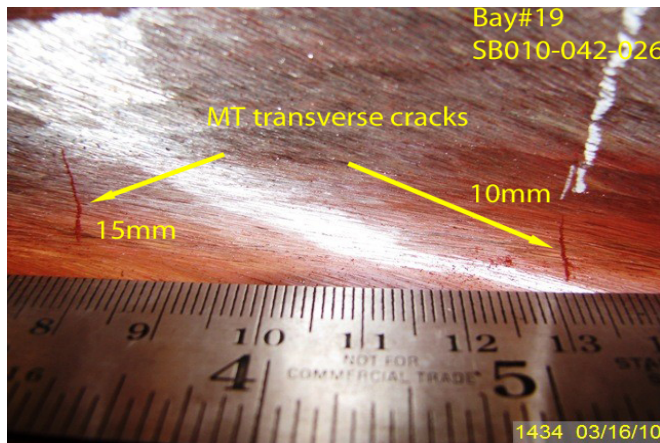
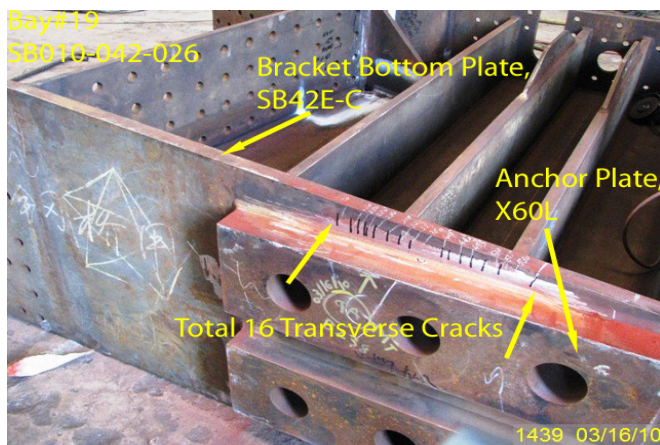
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Bay#19, Suspender Bracket

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

- (SB008-036E-031, 043, 055, 067, 001, 005, 12~17, 026, 032, 077)
- (SB008-036E-031, 043, 055, 067, 001, 005, 12~17, 026, 032, 077)
- (SB008-036E-031, 043, 055, 067, 001, 005, 12~17, 026, 032, 077)
- (SB008-036E-031, 043, 055, 067, 001, 005, 12~17, 032, 077)
- (SB008-036E-26)- Found Transverse crack

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Patel,Hiranch

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer